

Date: Friday, 6/16/2006 1:41:08 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FORWARD CAP
Job Number :	27559		
Estimate Number :	10501		
P.O. Number :	N/A	Part Number :	D2744
This Issue :	6/16/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2744 REV B1
First Issue :	6/15/2006	Project Number :	N/A
Previous Run :	25839	Drawing Revision :	B1
Written By :	SEE COMMENT BELOW	Material :	N/A
Checked & Approved By :		Due Date :	7/15/2006
Comment :	Est C 03.01.17 Reformat; Dwg revised KJ/RF		

Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.1914 sf(s)/Unit Total: 9.5708 sf(s)

Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick.

Use off-cuts

M5052H32S.080) Batch ~~M100947~~ M100682

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

- debur as necessary

SAD

06:06:21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M1

06:06:23

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J 06:06:26

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 59

H.M 06-06-30

6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/07/05

W 06/07/04

Date: Thursday, 6/15/2006 1:41:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FORWARD CAP
Job Number	: 27559		
Estimate Number	: 10501		
P.O. Number	:	Part Number	: D2744
This Issue	: 6/15/2006 S.O. No. :	Drawing Number	: D2744 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 25839	Material	:
Written By	:	Due Date	: 7/15/2006
Checked & Approved By	:	Qty:	60 Um: Each
Comment	: Est C 08.01.17 Reformat; Dwg revised KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.1914 sf(s)/Unit Total : 5.7425 sf(s)
 Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick.
 Use off-cuts
 M5052H32S.080) Batch _____

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: (6.650" x 3.125")

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per Folio FA309 and Dwg D2744
 Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:41:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD CAP

Job Number: 27559

Part Number: D2744

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

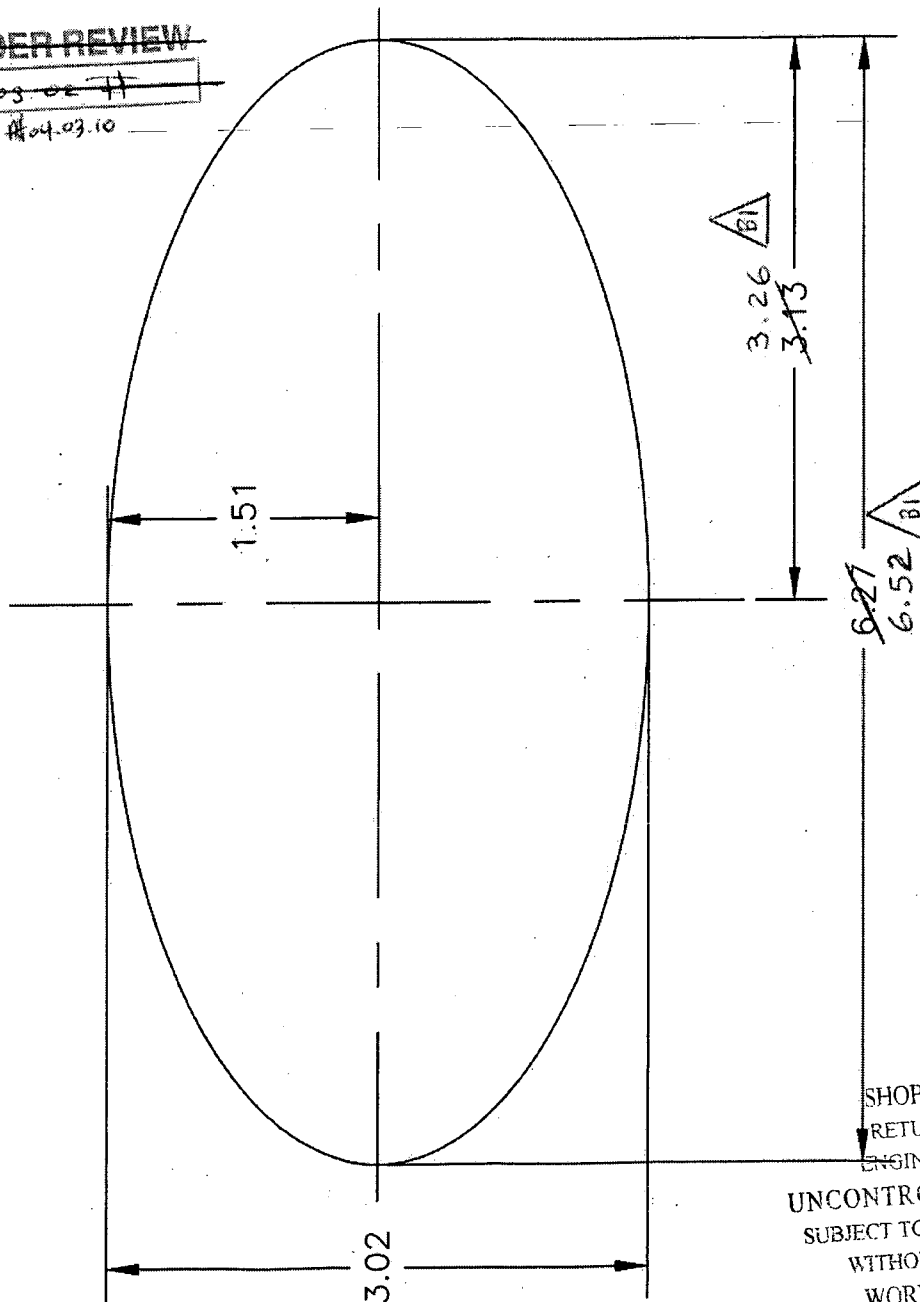
QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2744	REV. B SHEET 1 OF 1
DATE 02.12.18		TITLE CAP	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	02.12.18	REDESIGN	
BI	04.03.10	6.52 WAS 6.27; 3.26 WAS 3.13	

RELEASED
02.12.18

UNDER REVIEW
04.03.02
OK #04.03.10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27559

- NOTES
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK (REF. DART SPEC M6061T6S.080 OR M5052H32S.080)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES


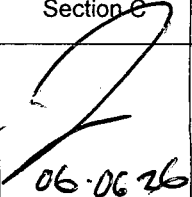

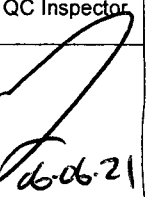
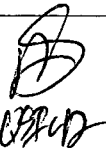
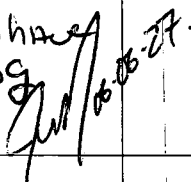
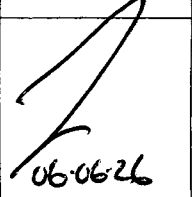

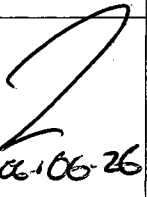
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-06-21	2.0	Parts, 250 under Dwg dimens in size on the total length.		Scrap & replace Qty of 50. destroy scrap parts.	SAD 06-07-05	 06-06-26	 06-06-26	 06-06-21
06-06-26	2	Parts still too short by .130.		Parts fit acceptable. Re-Acqs to DXF to have cut size match Dwg.	 06-06-27	 06-06-26	 06-06-26	 06-06-26

NOTE: Date & initial all entries

